

85456

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

100

Start Date: 08/06/2012 **Start Qty:** 100.00

Required Date: 22/06/2012 **Req'd Qty:** ~~100.00~~

100

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 17/06/08

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

Work Order ID 85456

85456

Page 2

June-08-12 10:01:42 AM

Item ID: D2651-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug

Start Date: 08/06/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

203 MB 12-6-25

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

0.00

Powder Coating

(Only larger section necessary) START TIME: 8:50
OVEN TEMPERATURE: 320°F FINISH TIME: 9:20

203X ✓ M/L 12/07/05

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

203 φ BLD-7-5.

M121841

Work Order ID 85456

June-08-12 10:01:42 AM

85456

Page 3

Item ID: D2651-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plug

Start Date: 08/06/2012 Start Qty: 100.00

100

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-2</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

203 ϕ 127.5OK 12/7/10ME
12-07-05

Picklist Print

June-08-12 10:01:46 AM

Page 1

Work Order ID: 85456

85456

Parent Item: D2651-1

D2651-1

Parent Item Name: Plug

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A02.04.15New Issue NG
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased		No		100	f	117.3680	0.0401	4.221053			

M6061T6R0 500

6061-T6 Round Bar .500"

Rp 12.6.21

Location

Loc Qty

Loc Code

MAT012

117.368

114488

1.997

117379

9.288

119043

106.083

8.9

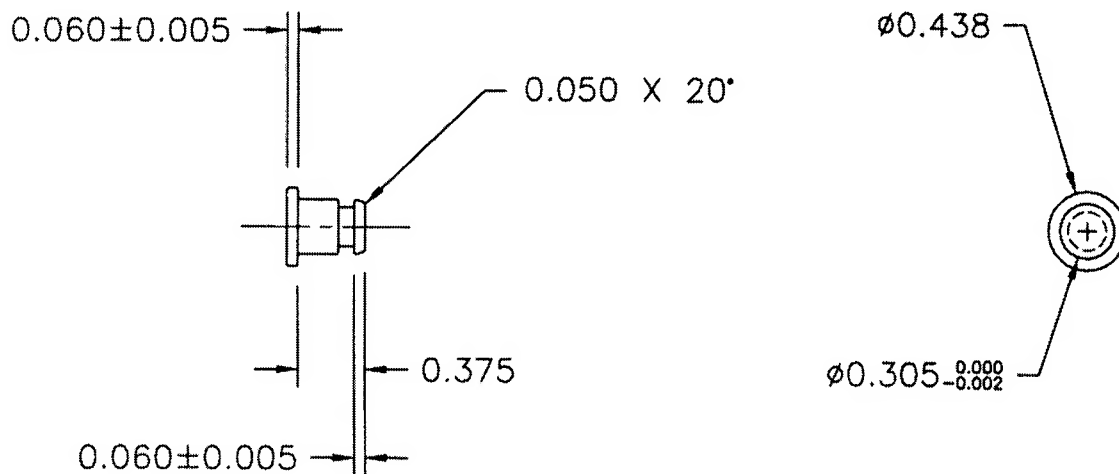


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

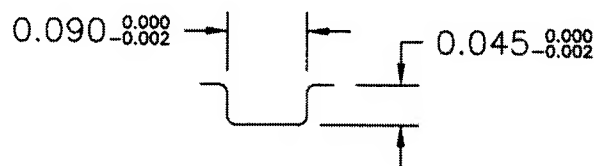
RELEASED

03.12.19 *[Signature]*

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



SHIP COPY
RETURN TO
ENGINEERING
(UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85456 M-5
12/06/08)

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.